

Date: Wednesday, 3/12/2008 1:41:40 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 37849	
Estimate Number : 10219	
P.O. Number :	Part Number : D219923
This Issue : 3/12/2008 S.O. No. :	Drawing Number : D2199 REV. E1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E1
Previous Run : 29387	Material :
Written By :	Due Date : 3/31/2008 Qty: 5 Um: Each
Checked & Approved By : <u>JA 08 03 12</u>	
Comment : Est:D 02.06.10 Rem polish & add finish NG/CC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 2.3100 f(s)/Unit Total : 11.5500 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall
(M304TR0750W049)

Batch No: M107245

SB 08/03/17

(5)

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 08/03/17

(5)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

CB 08/03/18

(5)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/03/18 (X)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107005

BL 08-03-19

(5)

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

M-L

08/03/19 (5X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:41:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 37849

Part Number: D219923

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5A264

Po 8/3/19 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 02/03/00 (5)

Job Completion



2008/3/19 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

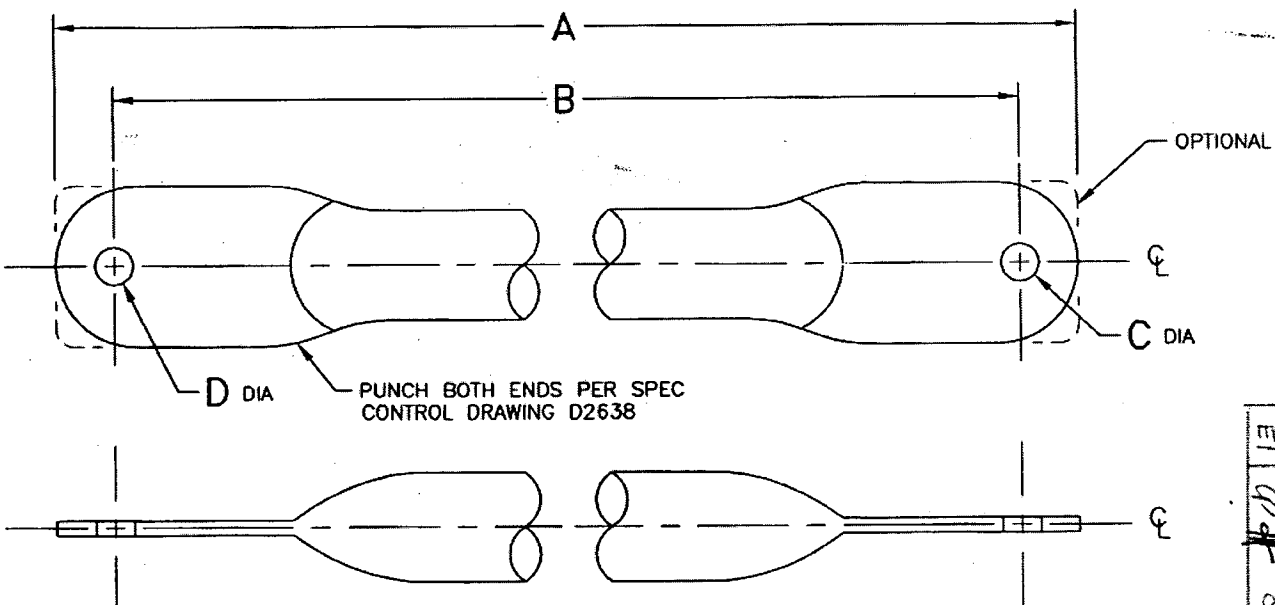
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
48.05.05 KE



	A	B	C	D
02199-1	18.30	17.50	0.257	0.257
02199-3	5.80	5.00	0.257	0.257
02199-5	22.64	21.84	0.257	0.316
02199-7	14.74	13.94	0.257	0.257
02199-9	16.52	15.72	0.257	0.257
02199-11	23.60	22.80	0.257	0.316
02199-13	15.96	15.16	0.257	0.257
02199-15	17.57	16.77	0.257	0.257
02199-17	28.05	27.25	0.257	0.316
02199-19	18.90	18.10	0.257	0.257
02199-21	10.80	10.00	0.257	0.257
02199-23	26.18	25.38	0.257	0.316
02199-25	19.93	19.13	0.257	0.257
02199-27	27.34	26.54	0.257	0.316
02199-29	21.11	20.31	0.257	0.257

B
 B
 B
 C
 C
 D
 E
 E

00.10.13
 P 00.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE 0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER PART QSI 005 4.3/EI

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2199	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		STRUT DETAILS	NTS
A	1993	NEW ISSUE	
B		ADDED -11, -13, AND -15	
C		ADDED -17 AND -19	
D		ADDED -21	
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
E1	02.03.22	ADD FINISH	

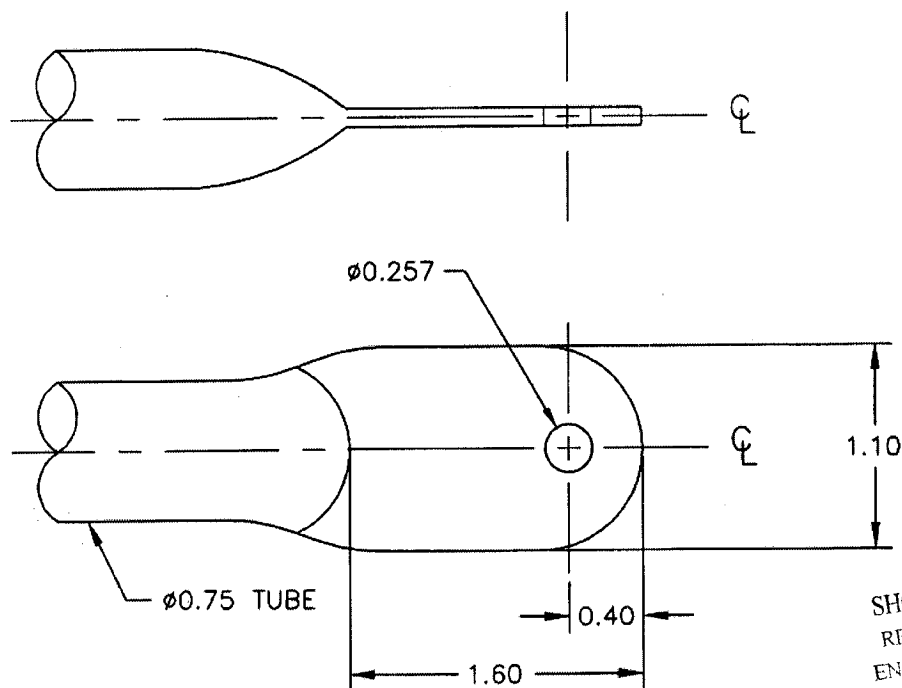
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MJB	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28	TITLE PUNCH DT8117 SPEC CONTROL		SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/09/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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WITHOUT NOTICE
WORK ORDER
NO. 37849